

Date: Wednesday, 27/08/2008 3:14:15 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GUIDE
 Job Number : 41644
 Estimate Number : 10367
 P.O. Number :
 This Issue : 27/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D31121
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3112 REV B
 Previous Run : 41072 Drawing Revision : B
 Material :
 Due Date : 05/09/2008 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : JUL 08.8.26
 Comment : Est. A 02.05.22 New Issue NG

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0625X01500 6061-T6 Bar .625 x 1.50



Comment: Qty.: 0.2385 f(s)/Unit Total: 4.7691 f(s)
 6061-T6 Bar .625 X 1.500"
 Material: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8)
 Bar ref DART spec M6061T6B
 Batch M101549 ml 08/08/30 20

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 0.625" x 1.500 bar x 2.625" long. ml 08/08/30 20

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA233
 Note: Engrave / scribe DART P/N on part as per dwg.
 Deburr break all unmarked sharp edges .005 to 0.010 N.A 08/08/30

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE N.A 08/08/30

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK S 08/08/02 (+19)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3112-1 PAR #: N/A Fault Category: Prod / Machine Parts NCR: Yes No DQA: D Date: 28/09/05
D412-694-03/04
 Resolution: _____ Disposition: _____ QA: N/C Closed: HD Date: 08/09/05

NCR: <u>41644</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/9/2	30	During QC inspection it was found that 20 parts were 0.412" out under tol. And in this happen RC employee has count	/bslur	Re machine parts all elected (Qty 20) so they conform to the Dwg.	SD 08/09/02	S 08/09/02	/bslur	08/09/02
				Remind employee to measure all parts				
				One @ Part SCRAP operator more no much no replace	SD 08/09/02	S 08/09/02		
		During on inspection (FAI) check But no parts are within tol. Human error / operator appears to have not measure this parts.	/bslur					

NOTE: Date & initial all entries

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Drawing Name: GUIDE

Job Number: 41644

Part Number: D31121

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(19X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-h

08/09/02

7.0

POWDER COATING

POWDER COATING



M106442



(19X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1 = 00
320 OF
1 = 30

M-h

08/09/02

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-02

(X19)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location:

ST66

18 08/09/02

X19

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

19 08/09/03

Job Completion



12 58-09-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

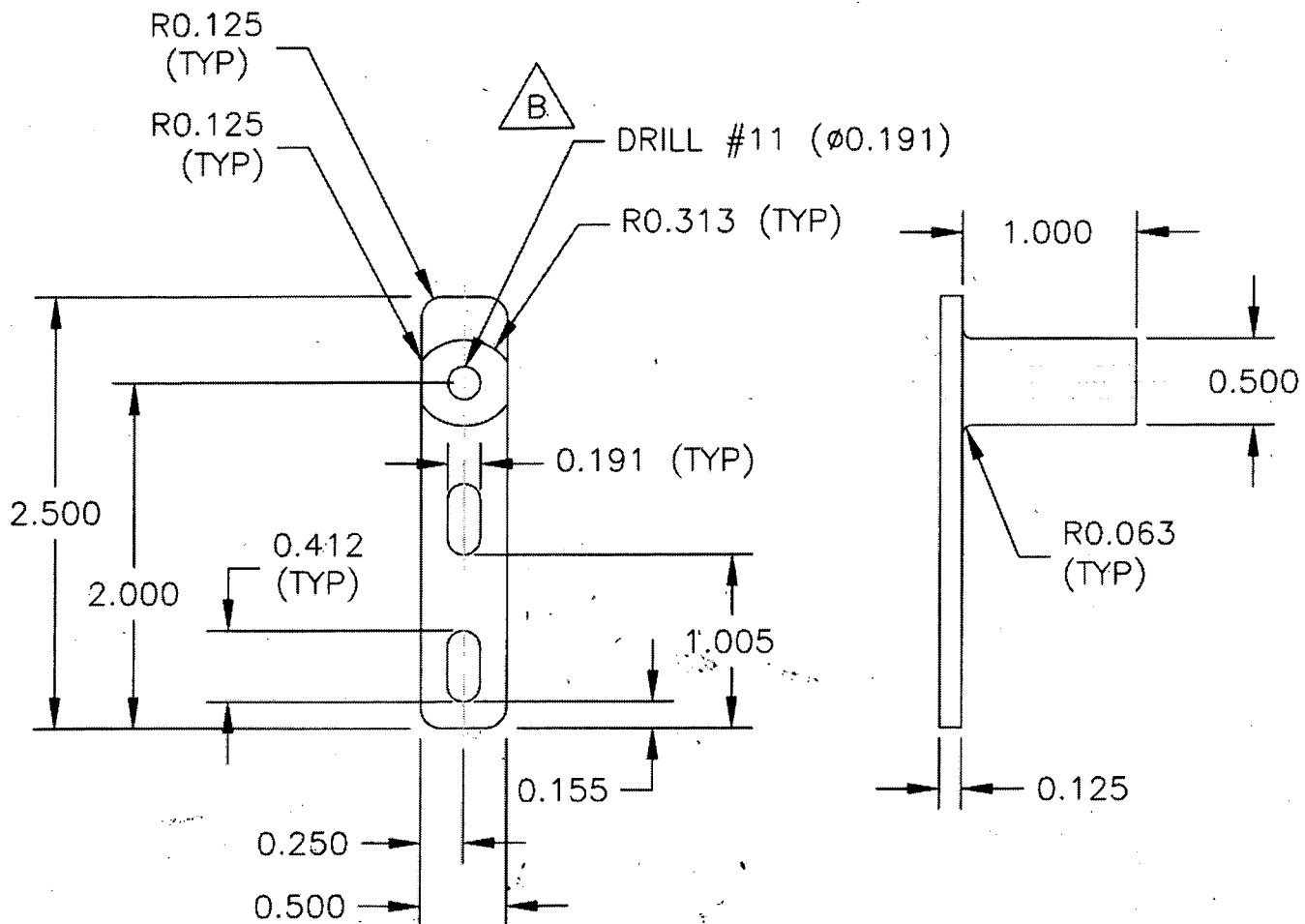
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3112	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE GUIDE	SCALE 1:1
A	02.04.12	NEW ISSUE	
B	04.10.18	ADD PART MARKING; Ø0.191 WAS Ø0.185	

RELEASED
04.11.23



D3112-1 GUIDE

NOTES:

- 1) MATERIAL: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF. DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-17
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41644

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